

Work Order ID 57557

April 8, 2010 10:04:26 AM



Page 1

Item ID: D3773-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Adapter

Start Date: 4/08/10 Start Qty: 4.00



Cust Item ID:

Required Date: 4/16/10 Req'd Qty: 4.00

Customer:

Reference:

10.04.08

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3773

Rev B

100

0.00



BAND SAW

0.00

Bandsaw

Memo

10/04/10

4 0

Jeaspa Bandsaw

Cut blank 2.700" long

110

0.00



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

8.9.10/04/13

4 0

HAAS CNC vertical machine #1

1- Mill as per Folio FA740 Rev: *AA* & Dwg D3773 Rev: *B* ☐ 2-Deburr
per dwg D3773

120

0.00



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

2.8.10/04/13

4 0

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57557

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Page 2

Item ID: D3773-1

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Setup Start



Revision ID:

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Item Name: Adapter

Start Date: 4/08/10

Start Qty: 4.00



Cust Item ID:

Required Date: 4/16/10

Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

DTP 10/04/13

4

Ø

140

Identify as per dwg & Stock Location: 249

0.00



Packaging

Memo

0.00

Packaging

10/04/13 (4)

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/14

MF 10-4-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 8, 2010 10:04:25 AM

Page 1

Work Order ID: 57557



Parent Item: D3773-1



Parent Item Name: Adapter

Start Date: 4/08/10

Required Date: 4/16/10

Comments: IPP Rev:A New Issue 08-05-07 JLM Verified By:DD

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304B1.500X1.500		Purchased	No			100	f	16.3000	0.9474			



304 bar 1.50 X1.50



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT54

16.3

108381

12

★ 112752

4.3

0.9474 ML 10/04/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



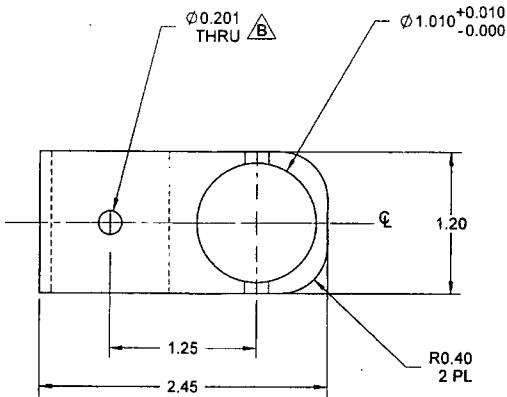
Lean principle

To be able to produce exactly:

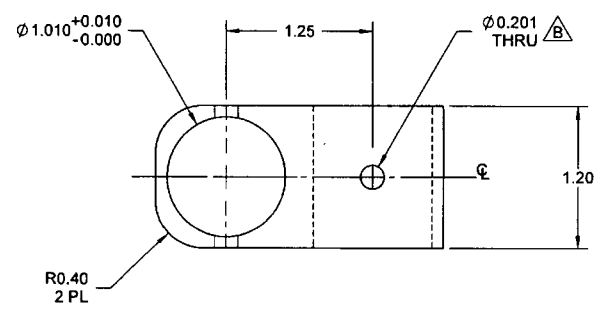
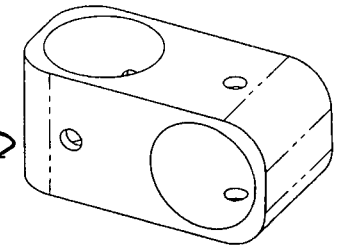
- **what is required**
- **when it is required**
- **the quantity required**

by the next step in the process.

Once a job started, it should ideally never stop



w/o 57557



D3773-1 ADAPTER

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS BAR (REF DART SPEC M304B)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.40 lbs

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3773	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		HEADREST ADAPTER	NTS
DATE	08.06.24	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Value stream mapping

- Value stream mapping is **the best way to identify where the high payoff** opportunities are, yet value stream mapping is the lean tool most likely to **not be used by** companies doing pretend lean!